

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000501**Date Inspected:** 29-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** CWI Arbin Huang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77m Mock-Up**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 Skin Plate-A Stiffener Plate 1 (Base Material, 75mm to 90mm thickness, is 345 steel) The preheat within the heat affected zone was observed to be between 107c to 141c, the welding wire was Supercored 71H with a diameter of 1.4mm and the WPS is WPS-B-T2232-TC-U5-F. The welder located on side-A (towards stiffener plate 2) was Liu Xie #066236 had a wire travel speed of 338.7 mm/min. with the amps recorded at 308 and the volts at 31.6. The welder on side-B, the opposite side, was Zhang Xiangrong #066763 and had a travel speed of 332.5 mm/min. the amps was recorded at 291 with the volts measured to be 30.6. Welding was being performed in a 2-G position. The welding of the stiffener plate had not been completed prior to the end of the shift.

Item-2 Skin Plate-C Marking and lay out was being performed for the placement of the stiffener plates.

Item-3 Skin Plate-D Grinding was being performed on the tack welding of the stiffener plates. Areas of concern were marked with soap stone and the person performing the grinding made aware of their location.

Summary of Conversations:

No project related conversation to record.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer